

Work Order ID 84807

84807

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Item ID: D2721-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206B Step Assembly
 Start Date: 23/05/2012 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 06/06/2012 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2721	Rev C

100	Large Fab	0.00				3	Ø		Ac 12.06.12
100									
Large Fab	Memo	0.00							
Large Fab	Cut D2721-1 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding								

110	Large Fab	0.00				3	Ø		Ac 12.06.20
110									
Large Fab	Memo	0.00							
Large Fab	Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT								
	A/R AL Rod Batch: <u>120854</u>								
	Grind end cap welds flush								Ac 12.06.25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				3	0	BE12/06/26	
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3	26	12.6.27	

(X3)
HY

Dart Aerospace Ltd

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Dart Aerospace Ltd

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		51269103					
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		51269103		43	41		
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3	26	12-73	

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating m121841	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8-30 OVEN TEMPERATURE: 320 FINISH TIME: 9-00	0.00 0.00				3X			M-1 12/07/04
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				3		20/BL	12/07/04
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 12163 Memo	0.00 0.00				3		DP	12/07/04

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
230									
QC	Memo	0.00							<i>12/7/11 (3)</i>
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							<i>12/7/11 (3)</i>
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							<i>12/7/11</i>
Quality Control									

D12-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 84807

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Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing
walk DD 10.02.24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

35.6100

1

3

D2622-120C

Step Extrusion

**

B83894 (x3) Ac 12.06.12

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	9.88	
81507	9.88	
WA013	9.36	
75781	2	
77612	7.36	

D2734

Manufactured No

110

Each

51.0000

1

3

D2734

Step End Plate

**

12.06.19

Location	Loc Qty	Loc Code
WA	51	
76985	5	
80682	16	
83322	30	

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 84807

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Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

D3461-1
D3461-1
Mounting Plate

Manufactured No 110 Each 45.0000 1 3

**

12.06.19

Location	Loc Qty	Loc Code
WA003	45	
58756	45	

3

D3461-3
D3461-3
Mounting Plate

Manufactured No 110 Each 2.0000 1 3

**

12.06.19

Location	Loc Qty	Loc Code
WA017 <u>B76232 =</u>	2	
41601	2	

3

D3461-5
D3461-5
Mounting Plate

Manufactured No 110 Each 18.0000 1 3

**

12.06.19

Location	Loc Qty	Loc Code
WA017	18	
33862	18	

3

D3461-7
D3461-7
Mounting Plate

Manufactured No 110 Each 20.0000 1 3

**

12.06.19

Location	Loc Qty	Loc Code
WA017	20	
33863	20	

3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2721-041

D2721-041

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

D2734

Manufactured

No

160

Each

51.0000

1

3

D2734

Step End Plate

**

12.06.27

Location

Loc Qty

Loc Code

WA

884563

51

76985

5

80682

16

83322

30

3

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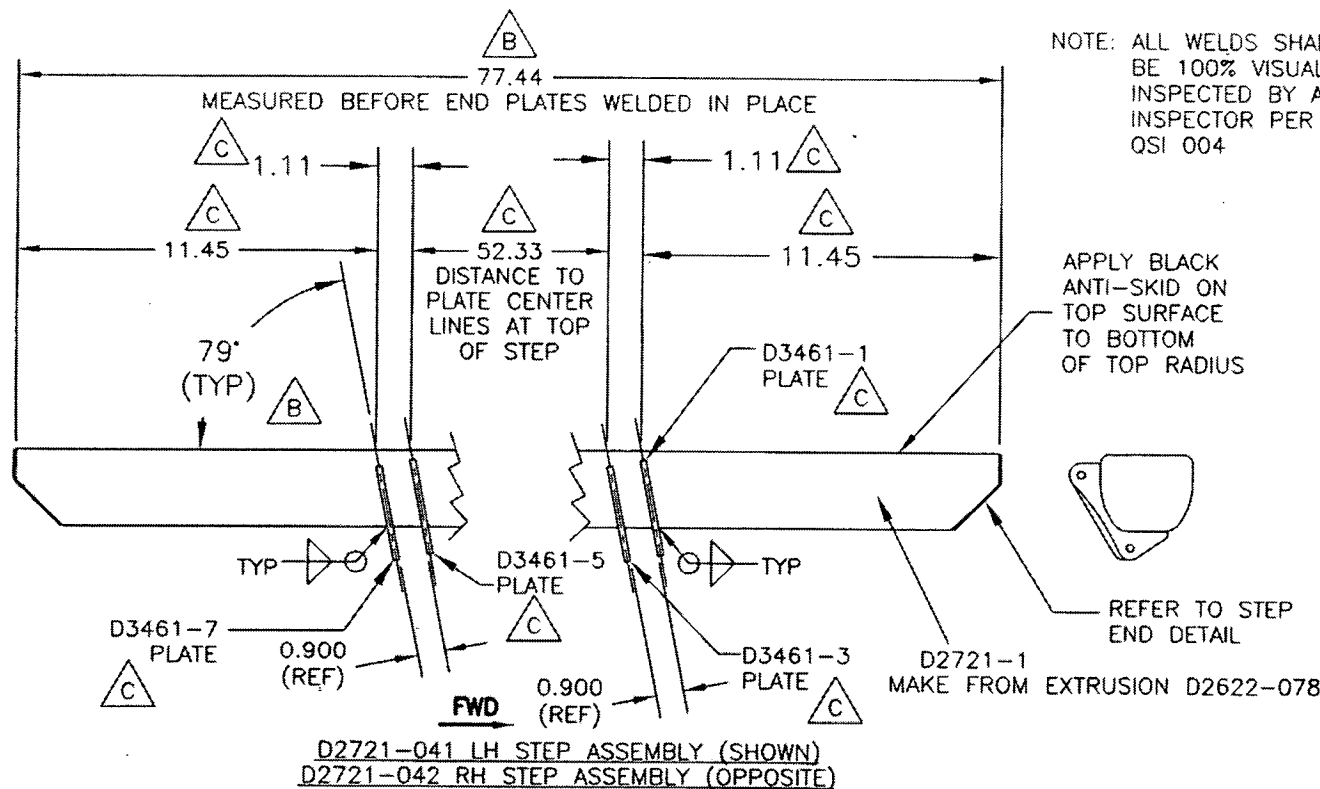
NOTE: Date & initial all entries

DART

RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

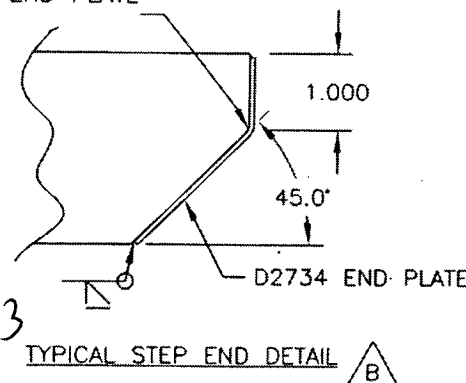
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
041	042		
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84807 MLW
12/05/23



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2721	REVISION
				NEW ISSUE
				79° WAS 80°, UPDATED WELD DETAIL
				REVISED TOLERANCES, 53.44 WAS 54.0
				RE-DESIGN, ADD D3461-1/-3/-5/-7
				SCALE
				NTS

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